

Work Order ID 165228

Thursday, August 17, 2017 7:30:48 AM

165228

Page 1

Item ID: D4017-7

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Rib

Start Date: 8/17/2017 Start Qty: 12.00

12

Cust Item ID:

Required Date: 8/18/2017 Req'd Qty: 12.00

12

Customer:

Reference:

AUG 17 2017

Approvals:

Process Plan:

DAS
21
9-89

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4017

F

100

0.00

100

Large Fab

Memo

0.00

Large Fab

1- Cut tube as per dwg D4017
2- Deburr and remove identify marks

12x DML 2017-8-22

110

QC6- All purchased or subcontracted products

0.00

110

QC

Memo

0.00

Quality Control

DAS
38
9-89

AUG 23 2017

12

120

Identify as per dwg & Stock Location: WADY

0.00

120

Packaging

Memo

0.12

Packaging

LOCATION: WA004

12x DML 2017-8-23

Work Order ID 165228

Thursday, August 17, 2017 7:30:48 AM

165228

Page 2

Item ID: D4017-7

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Rib

Start Date: 8/17/2017 Start Qty: 12.00

12

Cust Item ID:

Required Date: 8/18/2017 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21 - Final Inspection - Work Order Release

0.00

130

QC

Memo

1.20

DAS
21
9-89

AUG 24 2017

Quality Control

DAS
21
9-89

AUG 24 2017

Ull

Picklist Print

Thursday, August 17, 2017 7:30:52 AM

Page 1

Work Order ID: 165228

165228

Parent Item: D4017-7

D4017-7

Parent Item Name: Rib

Start Date: 8/17/2017

Required Date: 8/18/2017

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP RevA: new issue DD 09.11.26 verified by:EC IPP Rev:B as
per dwg RevA DD 10.03.06 verified by:EC IPP Rev:C as per dwg RevB
DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18
verified by:EC IPP Rev:E 11.01.18 chg qc5 to 6 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.049		Purchased	No			100	f	627.1895	0.0675	0.852632			

M304TS0 750W 049

**

D.M.L 2017-8-22

304 SQ Tube .75x.75x.049W

Location

Loc Qty

Loc Code

WA004

627.189474

137625

I

M137401

0.689474

M137625

285

M137824

2

M137934

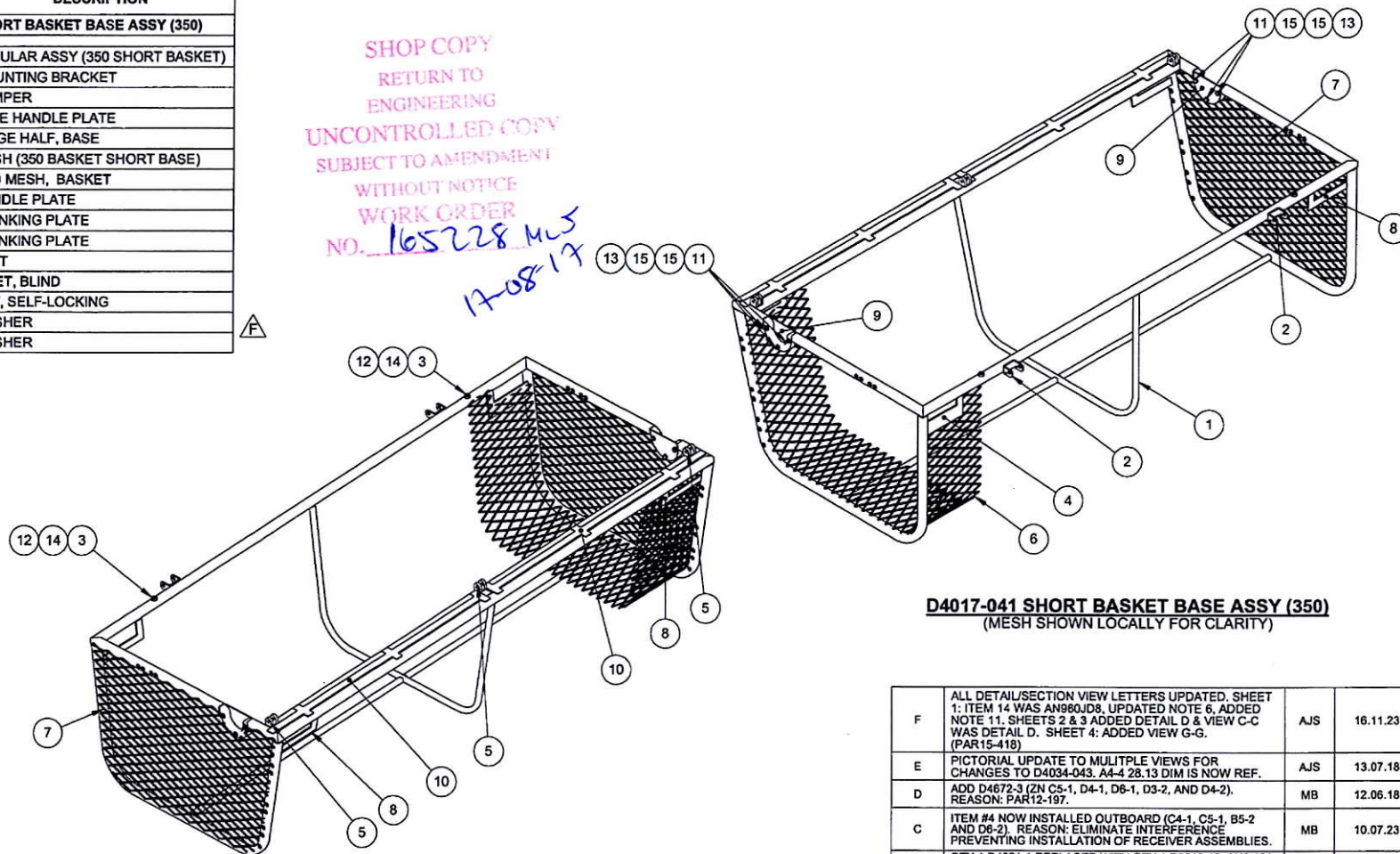
39.5

M138160

300

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4017-041	SHORT BASKET BASE ASSY (350)
1	1	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
2	2	D2581	MOUNTING BRACKET
3	2	D2931	BUMPER
4	1	D3913-15	WIDE HANDLE PLATE
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-3	MESH (350 BASKET SHORT BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	2	D4672-3	BLANKING PLATE
11	6	AN3-10A	BOLT
12	2	MS20600AD4W3	RIVET, BLIND
13	6	MS21042L3	NUT, SELF-LOCKING
14	2	NAS1149FN832P	WASHER
15	12	NAS1149F0332P	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 165228 MJS
17-08-17



D4017-041 SHORT BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

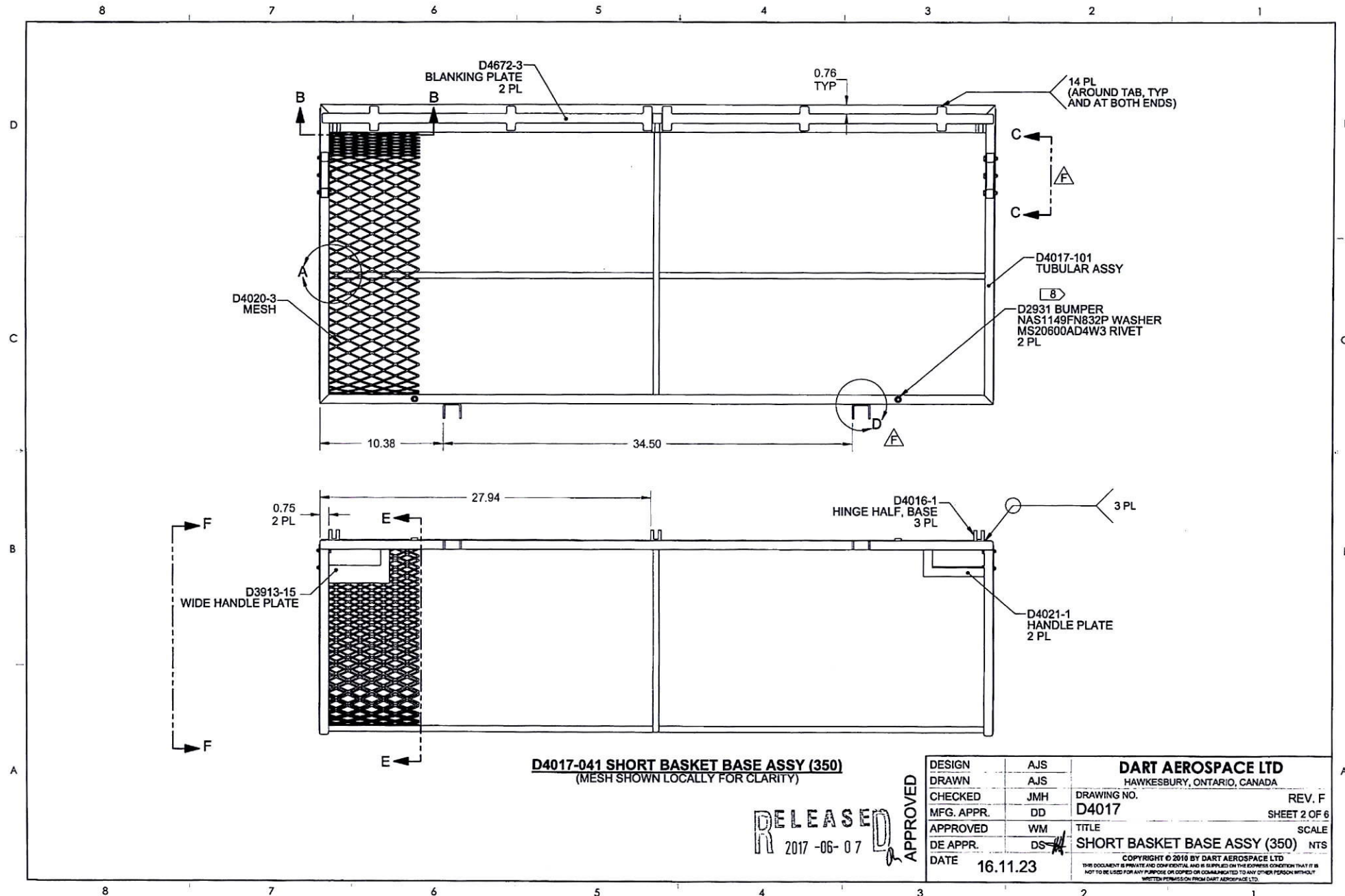
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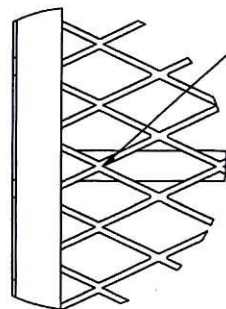
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART P/N AND B/N USING 0.13 (MINIMUM) HIGH LETTERING PER QSI 044 6.4
- 7) WEIGHT: 30.0 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004
- 11) MASK THIS AREA PRIOR TO FINISH

F	ALL DETAIL/SECTION VIEW LETTERS UPDATED. SHEET 1: ITEM 14 WAS AN960JD8, UPDATED NOTE 6, ADDED NOTE 11. SHEETS 2 & 3 ADDED DETAIL D & VIEW C-C WAS DETAIL D. SHEET 4: ADDED VIEW G-G. (PAR15-418)	AJS	16.11.23
E	PICTORIAL UPDATE TO MULTIPLE VIEWS FOR CHANGES TO D4034-043. A4-4 28.13 DIM IS NOW REF. REASON: PAR12-197.	AJS	13.07.18
D	ADD D4672-3 (2N C5-1, D4-1, D6-1, D3-2, AND D4-2).	MB	12.06.18
C	ITEM #4 NOW INSTALLED OUTBOARD (C4-1, C5-1, B5-2 AND D6-2). REASON: ELIMINATE INTERFERENCE PREVENTING INSTALLATION OF RECEIVER ASSEMBLIES.	MB	10.07.23
B	QTY 1 D4021-1 REPLACED WITH QTY 1 D3913-15; AN3-10A BOLT WAS AN3C10A; NAS1149F0332P WASHER WAS NAS1149C0332R; SECTION F-F UPDATED (D6-2); ITEMS RENUMBERED; DETAIL D UPDATED (A4-3)	JPH	10.03.25
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS	DRAWING NO.	REV. F
CHECKED	JMH	D4017	SHEET 1 OF 6
MFG. APPR.	DD	TITLE	SCALE
APPROVED	WM	SHORT BASKET BASE ASSY (350)	NTS
DE APPR.	DS	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	16.11.23		

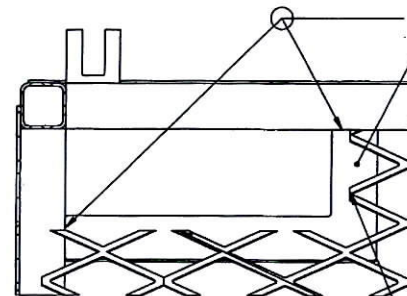
APPROVED

RELEASED
17-06-07
EEN 17-580

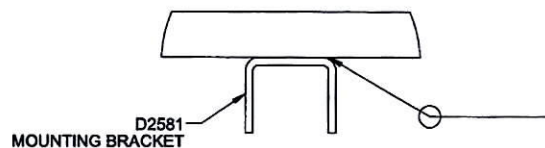




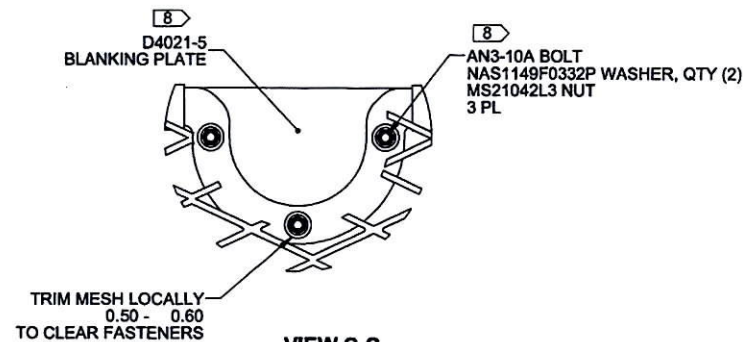
DETAIL A
SCALE 2X



SECTION B-B
TYPICAL FOR ALL
HANDLE PLATES



DETAIL D $\triangle$
2 PL

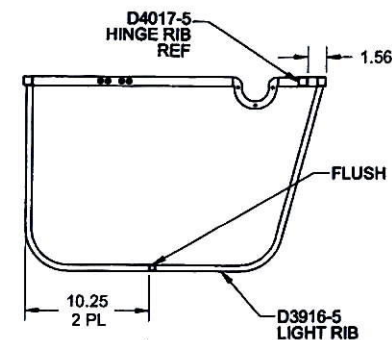
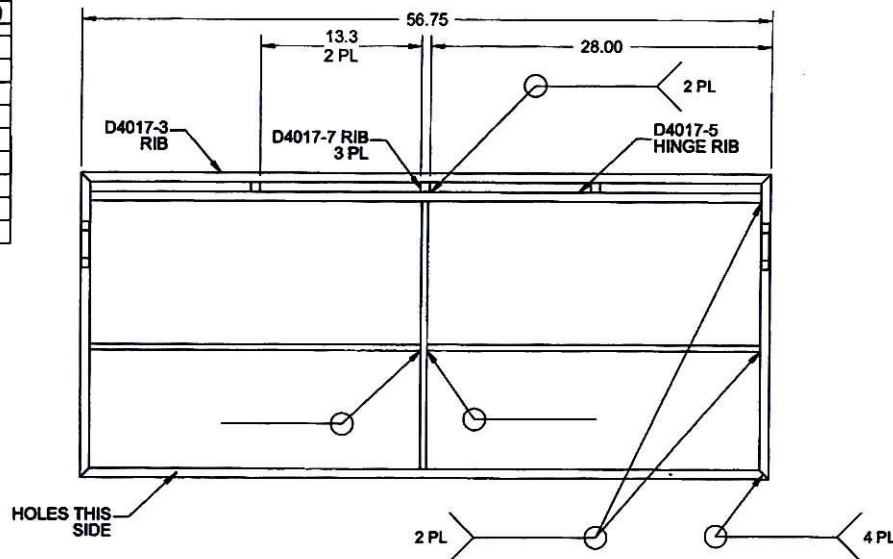


VIEW C-C
2 PL

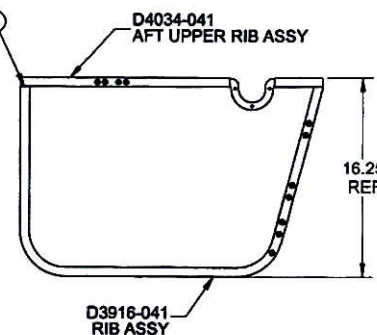
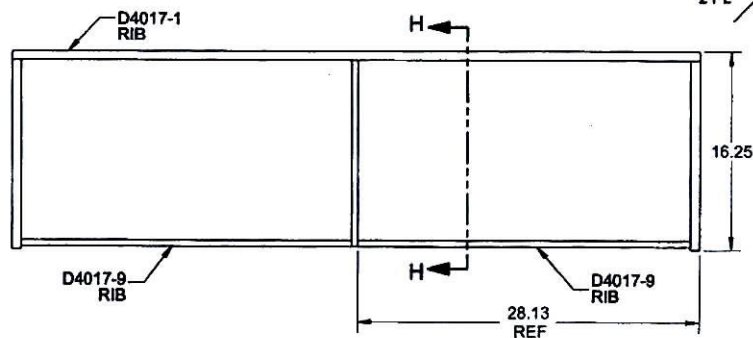
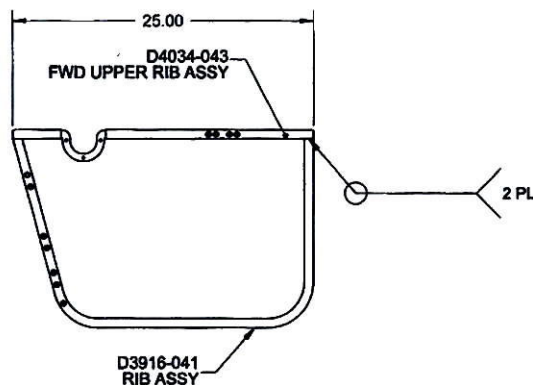
RELEASED
2017-06-07
APPROVED

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JMH	DRAWING NO.	REV. F
MFG. APPR.	DD	D4017	SHEET 3 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	SHORT BASKET BASE ASSY (350)	NTS
DATE	16.11.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY -101	P/N	DESCRIPTION
	X	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
1	1	D4017-1	RIB
2	1	D4017-3	RIB
3	1	D4017-5	HINGE RIB
4	3	D4017-7	RIB
5	2	D4017-9	RIB
6	1	D3916-5	LIGHT RIB
7	2	D3916-041	RIB ASSY
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY



SECTION H-H



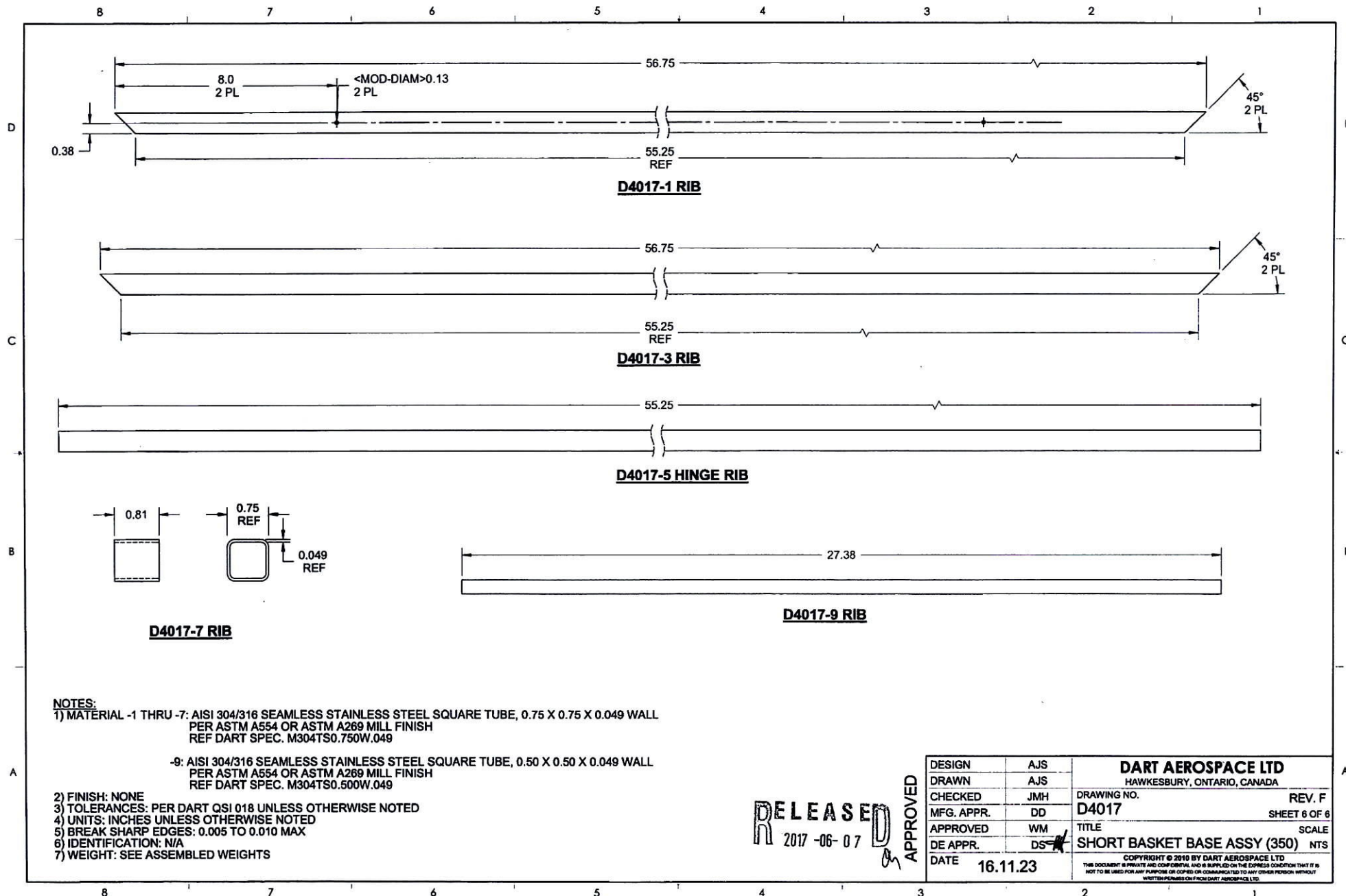
8 D4017-101 TUBULAR ASSY (350 SHORT BASKET)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 15.38 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS 0.06 FOR D4017-101
 - 9) WELD PER DART QSI 004

RELEASED
2017-06-07

APPROVED

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JMH	DRAWING NO.	REV. F
MFG. APPR.	DD	D4017	SHEET 5 OF 8
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	SHORT BASKET BASE ASSY (350)	NTS
DATE	16.11.23	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



Purchase Order Receipt Listing

Wednesday, May 24, 2017 3:29:05 PM

Page 1 of 1

All amounts are calculated in domestic currency.

All Vendors PO ID PO36329 Receipt Dates from 5/23/2017 to 5/23/2017 All Line Item Types

All Item ID/GL/WOs All Rec. Employees All Currencies

Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name		VC-MET002	Metaux Solutions								
PO36329	1		M304TS0.750W.049 f		5/24/2017	5/23/2017	500.0000	\$2.78	0.0000	0	\$1,390.80
CAD	No		304 SQ Tube .75x.75x.049W m137625	45 f	500.0000	PLOU01		\$1,390.80	0.0000	0	
	3		MSTEEL-A2-B0.500X1.250	1.275 f	5/24/2017	5/23/2017	24.0000	\$9.06	0.0000	0	\$217.40
	No		AISI A2 TOOL STEEL BAR, 0.500 X 1.250 m137625	f	24.0000	PLOU01		\$217.40	0.0000	0	
	4		71401-45		5/24/2017	5/23/2017	1.0000	\$0.00	0.0000	0	\$0.00
	No		PROCUREMENT QUALITY CLAUSES m137625		1.0000	PLOU01		\$0.00	0.0000	0	
Total Received Quantity:										525.0000	
Total Qty to Inspect (PO U/M):										0.0000	
Total Reject Quantity:										0.0000	
Total Receipt Value:										\$1,608.20	
Total Balance Due Quantity:										0.0000	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO36329**

Purchase Order Date 5/16/2017 1:03:43 PM

PO Print Date 5/16/2017

Page Number 1 of 2

Order From :

VC-MET002

METAUX SOLUTIONS
2625 BOUL JACQUES-CARTIER EST
LONGUEUIL, QC J4N 1L7
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
MAY 16 2017

Contact Name

Vendor Phone 800 558 8858

Ship To Contact

Ship To Phone

Ship Via: Journey Freight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
----------	--	------------------------	--------------------------------------	----	--------------------------------	---------------	----------------

1	M304TS0.750W.049	304 SQ Tube .75x.75x.049W	5/23/2017 Yes 5/23/2017		500.00 f	\$3.80	\$1,900.00
---	------------------	------------------------------	-------------------------------	--	-------------	--------	------------

MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBING
AS PER ASTM A554 MILL FINISH
OR
AS PER ASTM A269 MILL FINISH

Line Total: \$1,900.00

3	MSTEEL-A2-B0.500X1.250	AISI A2 TOOL STEEL BAR, 0.500 X 1.250	5/23/2017 Yes 5/23/2017		24.00 f	\$12.38	\$297.00
---	------------------------	--	-------------------------------	--	------------	---------	----------

MATERIAL: AISI A2 TOOL STEEL, ANNELED CONDITION
AS PER A681

NOTE: TOLERANCE -0+0" AS PER QUOTATION #16619
CUT AT 1.25"

SP17-5-24

Line Total: \$297.00

Note:

5/16/2017

Shipping Order

19/05/2017

METAUX SOLUTIONS INC
2625 BOUL JACQUES CARTIER EST
LONGUEUIL, QUEBEC
J4N 1L7
Tel.: 450 641-3330

Order : 125634
Reference : 36329
Ship : PICK UP / PICK UP

Customer: 6323336

Ship To

DART AEROSPACE LTD
1270, ABERDEEN STREET
HAWKESBURY, ONTARIO
K6A 1K7

Same

Tel.: 1 613 632-3336

Item No.	Description	Qty	Qty. Delivered	B/O Qty
	***** FACTURER E-MAIL ***** SUPER IMPORTANT SUR LE PACKING SLIP INSCRIRE LES HEAT N			
<u>SSQT34340494</u>	304 SQ TUBE .750 X .049 WALL 25 X 20' **** HT, TBG113301	500	<u>500</u>	<u>e</u>
TP12A2	A-2 PLATE TFA 1/2" THICK ht# 59498 2 X 1.25" -0+0 X 144" R/L	56	<u>56</u>	<u>e</u>

SHIP JOURNEY COLLECT
HP

817-5-24.

Shipping : _____
Package No : _____
Merchandise Received: _____
Ref. : _____

檢驗證明書
INSPECTION CERTIFICATE

524彰化縣溪州鄉中山路四段270號
No.270, Sec.4, Jungshan Rd., Shijou Shiang,
Chang-Hwa, Taiwan, R.O.C
http://www.ycinox.com
TEL : +886-4-8899666 FAX : +886-4-8899770



客戶名稱 Customer		產品名稱 Production		客戶編號 Customer No.		商業發票號碼 Commercial Invoice No.		證明書編號 Certificate No.	
		STAINLESS STEEL WELDED TUBE		FCA027		J16120312		170110P0122	
規格名稱 Specification		鋼種 Steel Grade		客戶採購單號 PO No.		提貨單編號 Weight No.		證明書日期 Date of Issue	
ASTM A554-16		MT-304		P006792		C17010081		2017/01/10	
								訂單編號 Order No.	
								PI 1611-087	
								P.I.號碼 P.I.NO.	

項目 Item No.	爐號 Heat No.	產品規格 Product Description		化學成份(%) Chemical Composition								拉伸試驗 Tension Test			*01 硬度試驗 HRB
		尺寸 Dimension	數量 Quantity Pcs	表面 Finish	C	Si	Mn	P	S	Ni	Cr	降伏 0.2%Y.S.	抗拉 T.S.	伸長率 E.L.	
Specification															
1	TBG113301	3/4" (19mm) x 3/4" (19mm) x 0.049" (1.25mm) x 20FT	60	MILL	80	100	200	45	30	1100	2000				
2	TBG091296	2 1/2" (63.5mm) x 2 1/2" (63.5mm) x 1/4" x 20FT	5	MILL	44	47	89	35	4	806	1820	312	660	52	85
3	TBG092176	2" (50.8mm) x 2" (50.8mm) x 1/4" x 20FT	13	MILL	19	28	141	26	3	800	1828	297	620	53	84
4	TBG121892	3" (76.2mm) x 3" (76.2mm) x 0.12" (3.05mm) x 20FT	23	MILL	24	31	139	28	8	804	1821	305	649	52	84
5	TBG122730	3" (76.2mm) x 3" (76.2mm) x 1/4" x 20FT	13	MILL	24	44	154	29	1	800	1817	308	690	50	88
6	TBG113722	4" (101.6mm) x 4" (101.6mm) x 0.12" (3.05mm) x 20FT	23	MILL	18	31	137	33	7	802	1827	298	626	53	86
7	TBG113712	4" (101.6mm) x 4" (101.6mm) x 0.180" (4.57mm) x 20FT	13	MILL	16	37	104	24	3	804	1837	289	651	52	83
8	TBG113689	4" (101.6mm) x 4" (101.6mm) x 1/4" x 20FT	25	MILL	19	31	138	35	7	804	1827	303	628	53	87
9	TBG122118	1 1/4" (31.8mm) x 1 1/4" (31.8mm) x 0.12" (3.05mm) x 20FT	25	MILL	21	44	156	26	2	810	1813	301	659	53	87
10	TBG113247	2" (50.8mm) x 2" (50.8mm) x 0.12" (3.05mm) x 20FT	25	MILL	42	49	89	34	2	813	1811	274	644	55	84
11	TBG113248	2" (50.8mm) x 2" (50.8mm) x 0.12" (3.05mm) x 20FT	25	MILL	54	48	134	35	2	812	1819	275	612	53	82
					44	41	89	39	6	801	1808	280	644	53	84
		TOTAL:	275												

附註 Remark		檢驗 Note	
		This certificate complies to 3.1/EN 10204:2004.	
		*01= Hardness Test * Gauge Length: 50mm	
		Visual Inspection (Surface) and Dimension Check : OK	
		1MPa=1N/mm ² ≈10bar=145psi=10.2kgf/cm ²	

Surveyor By	茲證明本文所列產品，均依材料標準製造及試驗，並符合標準之要求，與無輻射污染	1.ISO 9001:2008 (No.01 100 056299) 2.PED / AD2000 (No.01 202 TWWQ-05 0105) 3.ISO 14001:2004 (No.01 104 822 096385) 4.OHSAS 18001:2007 (No.01 113 822 096385)	Manager of Quality Assurance Department
N/A	We hereby certify that material described herein has been manufactured and tested with satisfactory results in accordance with the requirement of the above material specification. The material described above has been found free of radiation by raw material supplier.		Jie Yi

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: M304750, 750W, 049

PO / BATCH NO.: 036329/M137625

DATE: MAY 25 2017

MATERIAL CERT REC'D: yes
 QUANTITY RECEIVED: 500'
 QUANTITY INSPECTED: 500'
 QUANTITY REJECTED: 0

THICKNESS ORDERED: .049
 THICKNESS RECEIVED: .045
 SHEET SIZE ORDERED: NA
 SHEET SIZE RECEIVED: NA

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y (N)	
CORRECT FINISH	(Y) N	
CORROSION	Y (N)	
CORRECT GRAIN DIRECTION	(Y) N	
CORRECT MATERIAL PER M-DRAWING	(Y) N	ASTM A554
CORRECT THICKNESS	(Y) N	
PHOTO REQUIRED	Y (N)	
CORRECT REF # TO LINK CERT	(Y) N	HT # T8G113301
CORRECT MATERIAL IDENTIFICATION	(Y) N	
CORRECT M# ON THE MATERIAL	(Y) N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y (N)	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y (N)	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW				
TYPE OF MATERIAL	HRC	HRB	DUR A	DUR D
SIZE OF TEST SAMPLE				
HARDNESS / DUROMETER READING				

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>CB</u>		SIGNED OFF BY: _____	
DATE: <u>MAY 25 2017</u>		DATE: _____	

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in